

Work Order ID 61206

Wednesday, August 11, 2010 10:13:49 AM



Page 1

Item ID: D3502-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Support

Start Date: 8/11/2010 Start Qty: 12.00



Cust Item ID:

Required Date: 8/25/2010 Req'd Qty: 12.00



Customer:

Reference:

Run Start



Approvals: Process Plan: MF

Date: 10-8-11

Tooling:

Date: 10-8-11

QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

D3502

Rev B

100

0.00



BAND SAW

Bandsaw

Memo

0.00

28 10/08/22

12

9

Jeaspa Bandsaw

Cut blank 3.475 " long 1 BLANK MAKES 2 PARTS

110

0.00



HAAS CNC VERTICAL MACHINING #1

HAAS 1

Memo

0.00

28 10/08/22

12

9

HAAS CNC vertical machine #1

1- Mill as per Folio FA649 Rev: AA & Dwg D3502 Rev: B 2-Deburr per dwg D3502

120

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

28 10/08/22

12

9

Quality Control

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Page 2

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Customer:

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 QC Quality Control	QC8- Inspect parts - second check Memo	0.00 0.00		GA	10/08/24	12	0		
140 Small Fab Small Fab	Small Fab Memo Mark hole position using DT9430□Drill as per Dwg D3502.	0.00 0.00							
150 HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1 Memo	0.00 0.00		JD	10/08/25	x12	0		

9/5/08/25 (12)

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Page 3

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Start Date: 8/11/2010	Start Qty: 12.00		Cust Item ID:	
Required Date: 8/25/2010	Req'd Qty: 12.00		Customer:	
Reference:				

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run Start	
	QC:	Date:	SPC (Y/N):	Date:	Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160 Powdercoat Powder Coating	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum <i>M115291</i> Memo START TIME: <i>10:45</i> <i>8:20</i> FINISH TIME: <i>11:15</i> OVEN TEMPERATURE:	0.00 0.00							<i>12 BR 10-8-26</i>
170 QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00							<i>=7 JH 10/08/27</i> <i>12</i>
180 Packaging Packaging	Identify as per dwg & Stock Location <i>63</i> Memo	0.00 0.00							<i>10/8/31</i> <i>12 SP</i>

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Wednesday, August 11, 2010 10:13:49 AM



Page 4

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Cust Item ID:

Required Date: 8/25/2010 Req'd Qty: 12.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

190

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/08/31 *[Signature]*

CL10/8/31

Picklist Print

Wednesday, August 11, 2010 10:13:48 AM

Page 1
1

Work Order ID: 61206



Parent Item: D3502-1



Parent Item Name: Support

Start Date: 8/11/2010

Required Date: 8/25/2010

Start Qty: 12.00

Required Qty: 12.00

Comments: IPP Rev:A New Issue 06-07-06 JLM
IPP Rev:B Add tooling hole 07-03-28
Esr rev C added DT9430 08.11.03 EC verified by:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6B1.000X04.00 0		Purchased	No			100	f	77.1000	0.289	3.650526			
6061-T6 Bar 1.00 x 4.00													

Location

Loc Qty

Loc Code

MAT03

77.1

107221

58.58

114352

18.52

3.6506

2F 10/08/22

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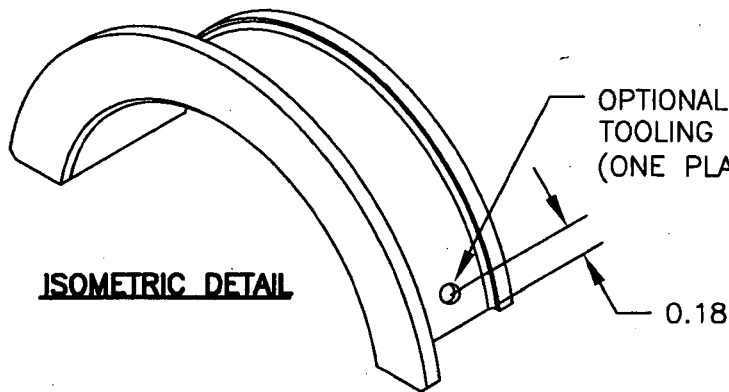
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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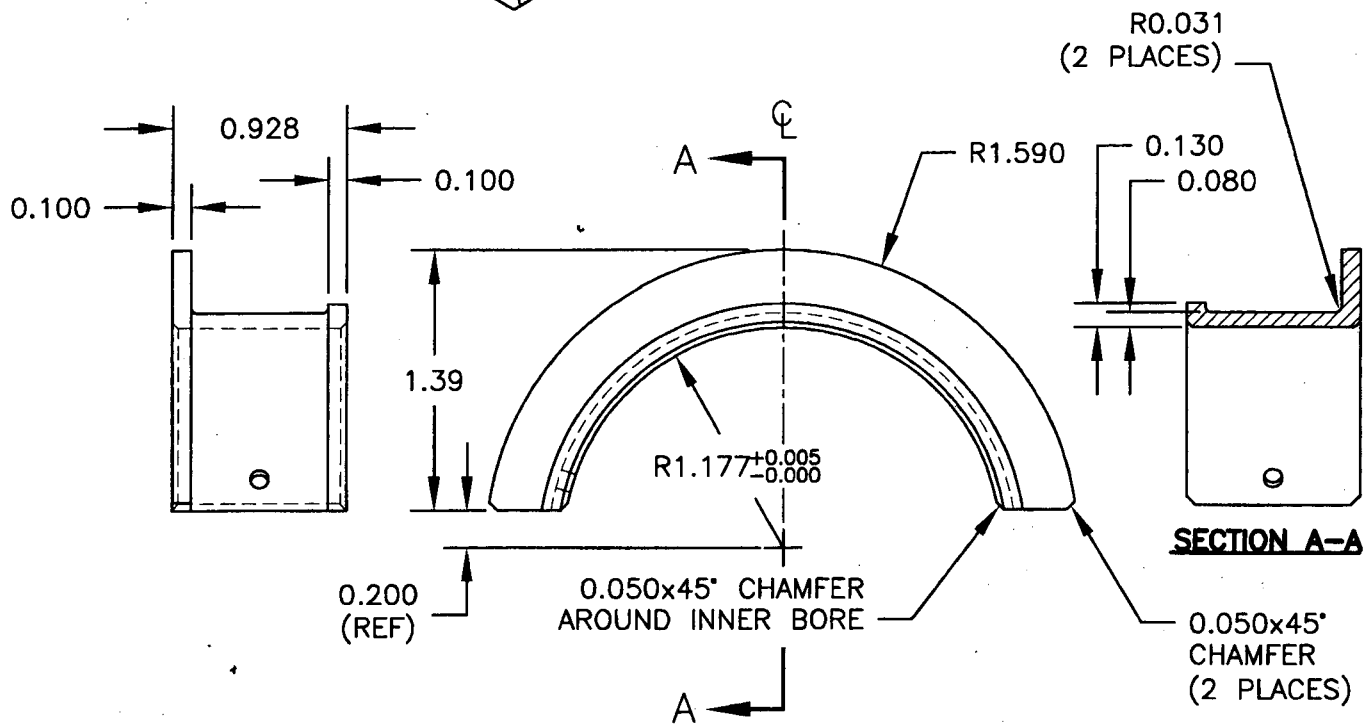
DART

DESIGN <i>qp</i>	DRAWN BY <i>qp</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3502	REV. B SHEET 1 OF 1
DATE 06.10.31	TITLE SUPPORT		SCALE 1:1
A	06.04.18	NEW ISSUE	
B	06.10.31	ADD TOOLING HOLE FOR FINISHING	

**ISOMETRIC DETAIL**

OPTIONAL $\phi 0.098$ (DRILL #40)
TOOLING HOLE, CENTERED ON PART
(ONE PLACE ONLY)

61206

RELEASED
06.12.46 *qp*
PER ECN 885**D3502-1 SUPPORT**

- 1) MATERIAL: 6061-T6 ROUND BAR (REF DART SPEC. M6061T6R)
- 2) BREAK ALL UNMARKED SHARP EDGES 0.010 TO 0.020
- 3) PART IS SYMMETRIC ABOUT CENTERLINE
- 4) TOLERANCES ARE PER DART QSI 018 (REF. X.XXX = ± 0.010 , X.XX = ± 0.030) UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3

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